011568

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Tel (613) 632-5200
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D206-642-312BL
Job Sheet 198744

Part No: D206-642-312BL **Job Qty:** 1 pcs

Part Name: Skidtube RH, Low & High Gear with Standard Wearplates (Ael Blue)

Part Weight: 0 lbs **Status:** New **Priority:** Medium

Job Created: 8/6/19 **Job Tracking No:**

Due Date: 8/30/19 **Created By:** Marie Lajeunesse

Type: SOLD **Description:** ORDER 18565

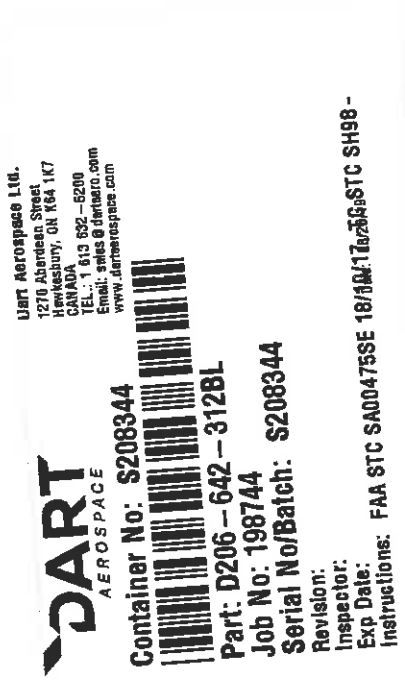
Note: DWG REV Q SHEETS 29-30 IPP Rev: J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec IPP Rev:L 08-09-29 as per DSI9421 DD verified by: EC IPP Rev:M 09-03-02 as per DSI9440 rev.a verified by:EC IPP Rev:N 09-03-03 as per DSI9421 rev.b verified by:EC IPP Rev:O as per REV.N DD 10.04.19 verified by:EC IPP Rev:P 14.04.25 ECN14-520 DD verf:JLM IPP REV:Q 15.10.09 ADDED BL DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter/Supplier Workcenter / Supplier Lead Time	Sign-off
110	Packaging 1 - Pick Kit	1 pcs		8/30/19	0.00	0.00	Packaging 1 - 1	
							Packaging 1 - 2	
							Packaging 1 - 3	
							Packaging 1 - 4	
							Packaging 1 - 5	
							Packaging 1 - 6	
							Packaging 1 - 7	
							Packaging 1 - 8	
							Packaging 1 - 9	
							Packaging 1 - 10	
							Packaging 1 - 11	
							Packaging 1 - 12	
							Packaging 1 - 13	
							Packaging 1 - 14	
							Packaging 1 - 15	
							Packaging 1 - 16	
							Packaging 1 - 17	
							Packaging 1 - 18	
							Packaging 1 - 19	
							Packaging 1 - 20	
							Packaging 1 - 21	
							Packaging 1 - 22	
							Packaging 1 - 23	
							Packaging 1 - 24	
							Packaging 1 - 25	
							Packaging 1 - 26	
							Packaging 1 - 27	
							Packaging 1 - 28	



				Packaging 1 - 29	
				Packaging 1 - 30	
				Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
115 **Packaging 1-1 - Pick Kit - B4B**	1 pcs	8/30/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B NL.	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
120 **QC 4**	1 pcs	8/30/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
130 **Packaging 3-1 - Stock - B4B**	1 pcs	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	

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2019

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	ML
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS SEP 2 0 2019
				Packaging 3 - 36 - B4B	21
135 **DC - 1 - B4B**	1 pcs	8/30/19	0.00 0.00	DC - 1 - B4B	8-29
				DC - 2 - B4B	DAS 21
140 **QC 21 - FG**	1 pcs	8/30/19	0.00 0.00	QC 21 - FG - 21	9-59
				QC 21 - FG - 70	SEP 2 0 2019

Part Op **110** - Pick Kit
Descriptions: **120** - QC4- 100% Inspect kits for completeness
130 - Identify and pack for shipping as per PPP D206-642-312 Location: _____ PPP Rev: _____
135 - Document Control - Photocopy bluefile and create labels per PPP D206-642-312 CHG008
140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-41A	Bolt	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5161490
AN4-6A	Bolt	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	5156423
AN4C5A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5167395
AN5-10A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5200196
AN5-11A	Bolt	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5167552
AN5-12A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5003976
D206-648-013BL	Ground Handling Wheel Modification	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5174200
D2652	Bushing	16 pcs (16 ea)	110-Packaging 1 - Pick Kit	5195628
D2712	Set Screw	10 pcs (10 ea)	110-Packaging 1 - Pick Kit	5128866
D2932-2BL	Saddle RH Out, 206	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5160588
D2933-2BL	Saddle RH In, 206	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5165450
D2934	Saddle Spacer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5194744
D2935	Saddle Spacer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5190069
D2938-2BL	Saddle RH Out, 206	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5163973
D2939-2BL	Saddle RH In, 206	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5121226
D3407-043BL	Tow Ring, Blue Prime/Paint	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5020079
D3413-1BL	O-Ring	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5174520
D3456-1	Washer	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5199355
D3457-1	Washer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5088582XL3172538
MS21042L3	Nut	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5204283
MS21042L4	Nut	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	5192449
MS21043-4	Nut	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5198126
NAS1149C0463R	Washer (AN960C416)	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5174669
NAS1149D0363J	Washer	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5191331
NAS1149D0463J	Washer	24 Ea (24 ea)	110-Packaging 1 - Pick Kit	5195265
NAS1149D0563J	Washer	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5162690
D206-642-341BL	Replacement Skidtube (Fits LH or RH)	1 pcs (1 ea)	115-Packaging 1-1 - Pick Kit - B4B	5207068

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3-41A	8	119	0
	AN4-6A	12	423	0
	AN4C5A	1	51	0
	AN5-10A	4	132	0
	AN5-11A	8	143	0
	AN5-12A	4	258	0
	D206-648-013BL	1	1	0
	D2652	16	353	0
	D2712	10	449	0
	D2932-2BL	1	2	0
	D2933-2BL	1	3	0
	D2934	2	21	0
	D2935	2	38	0
	D2938-2BL	1	2	0
	D2939-2BL	1	2	0
	D3407-043BL	1	3	0
	D3413-1BL	1	1	0
	D3456-1	1	183	0
	D3457-1	2	23	0
	MS21042L3	8	725	0
	MS21042L4	12	3,079	0
	MS21043-4	1	830	0
	NAS1149C0463R	1	250	0
	NAS1149D0363J	8	1,718	0
	NAS1149D0463J	24	4,268	0
	NAS1149D0563J	8	2,053	0
115-Packaging 1-1 - Pick Kit - B4B	D206-642-341BL	1	0	0

Part Specifications

Specifications could not be found.

Plex 8/6/19 9:34 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only ☐

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Water Jet ☐
Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐
Quality ☐

Date :	Sequence #:	QTY Affected :	MRB (QSI042)

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor
		QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong
☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance
☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing
☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish
☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing
☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Misread
☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up

Other/Details:

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG (1)
2B					14			4		D2651-3	* O-RING (1)
3					1			1		D2646	* AFT CAP (1)
4					2			2		MS27039-1-08	* SCREW (1)
5					2			2		NAS1149D0332J	* WASHER (1) (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT (2)
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT (2)
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	*INSERT (1) (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
50							1	1		D4364-041	FWD WEARPLATE ASSY
51							1	1		D4364-043	AFT WEARPLATE ASSY
52							18	18		D3873-1	BUSHING
53							4			D2649	SPACER
54A							9	9		AN3-36A	BOLT
54B							9	9		NAS1149C0332R	WASHER (OR AN960C10L)
54C							9	9		MS21042-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D2650-5 OR D4361-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Change Record

Part Number: D206-642-311 /-311BL /-311G/-312/-312BL/-312G

Description: SKIDTUBE , LH/RH

CHG #	DATE	BY	RELEVANT DOCUMENTS	ECN #
001	98.12.14	DS	MDL-D119-646 REV I	
002	99.04.28	DS	MDL-D206-642 REV J	
			ADDED SADDLE SPACERS PER DSI 9150 REV A	
			D2655 TOW RING SHIPPED LOOSE RATHER THAN INSTALLED	
			ON SKIDTUBE	
003	00.03.14	DS	CHANGE TO D2968-041 TOW RING PER DSI 9181 REV A	
004	05.10.04	CP	ADD D3429-1 WEARPAD PER MDL-D206-642 REV O	
005	08.10.07	KJ	DSI 9421 REV A, D2650 REV F	08-538
006	09.02.19	KJ	DSI 9421 REV B, DSI 9440 REV A, D206-648 REV B, D3414 REV B	09-531
007	12.11.16	KJ	DEO-D2650-F-1, DEO-D3804-A-1, D4720 REV A	12-679
008	14.04.17	KJ	MDL-D206-642 REV AF, IIN-D206-642 REV Q, ICA-D206-642 REV 6	14-520
			D3289 REV E, D3415, D3805 REV C, D4956 REV A	
			D4364, D4366, D4368, D4370 REV B	